

Date: Wednesday, 9/12/2007 12:13:30 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 34603  
 Estimate Number : 12926  
 P.O. Number :  
 This Issue : 9/12/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 34192  
 Written By :  
 Checked & Approved By : 07.09.12  
 Comment : Est Rev A New Issue 07-07-04 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
 REVIEW La  
 Part Number : D293819P  
 Drawing Number : D2938 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 9/30/2007 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: 334873 IP 08/03/07

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr IP 08/03/07

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet IP 08/03/07

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET IP 08/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/03/14

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 34603

Part Number: D293810P

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/03/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/03/12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-12 (X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST429

AS 08/03/13 (X10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/14

Job Completion



76 powder coat white  
per QSI 005

m107005

(10)

K

FL 08/03/12

mi 2008/3/13 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34603
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.131	.131	.134	.135		
B	0.100	0.140		.132	.130	.133	.135		
C	0.100	0.140		.119	.119	.118	.118		
D	0.210	0.230		.223	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.575	1.578	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.118	.118	.119	.118		
O	0.540	0.560		.550	.550	.550	.549		
P	0.490	0.510		.507	.506	.506	.505		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.260	.260	.260	.260		
T	0.100	0.180		.160	.160	.160	.160		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.256	1.250	1.250		
Y	1.565	1.585		1.580	1.576	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	08/23/08

Audited by:	SD
Date:	08/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34603
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.135	.137	.135	.130		
B	0.100	0.140		.136	.138	.135	.130		
C	0.100	0.140		.127	.128	.127	.127		
D	0.210	0.230		.220	.225	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.500	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.579	1.579		
J	2.495	2.505		2.501	2.501	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.237	.237	.238	.238		
N	0.100	0.140		.110	.110	.110	.110		
O	0.540	0.560		.549	.549	.549	.549		
P	0.490	0.510		.500	.500	.495	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.750	2.750	2.740	2.740		
S	0.240	0.270		.260	.260	.267	.267		
T	0.100	0.180		.160	.160	.160	.160		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.270	1.270	1.260	1.260		
Y	1.565	1.585		1.570	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	08/03/10

Audited by:	SD
Date:	08/03/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34603
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

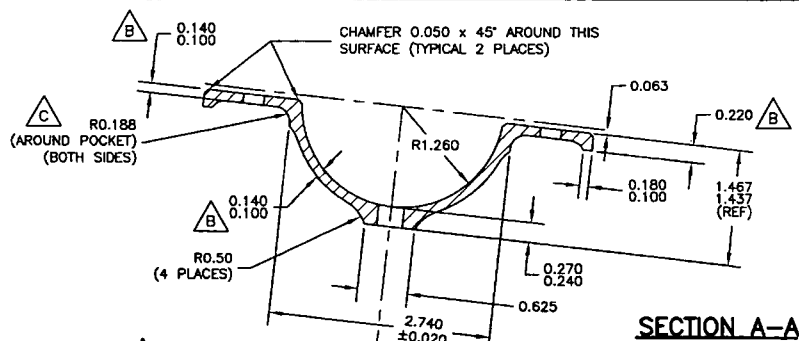
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.130	.130				
B	0.100	0.140		.130	.130				
C	0.100	0.140		.125	.125				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.575	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.257				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.557	.557				
P	0.490	0.510		.505	.495				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.750	2.750				
S	0.240	0.270		.250	.260				
T	0.100	0.180		.160	.160				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.360	1.360				
W	0.316	0.321		.320	.320				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

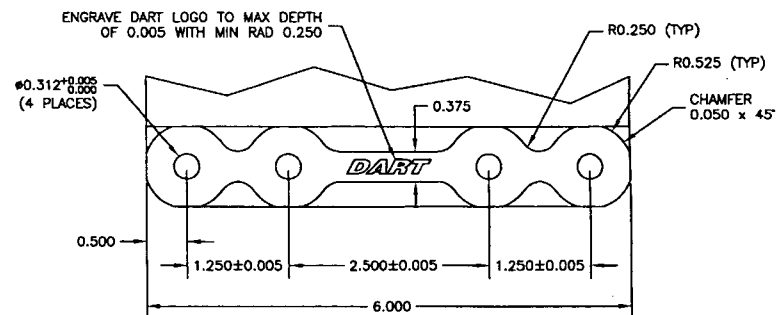
Measured by: SF
Date: 08/03/10

Audited by: SD
Date: 08/03/11

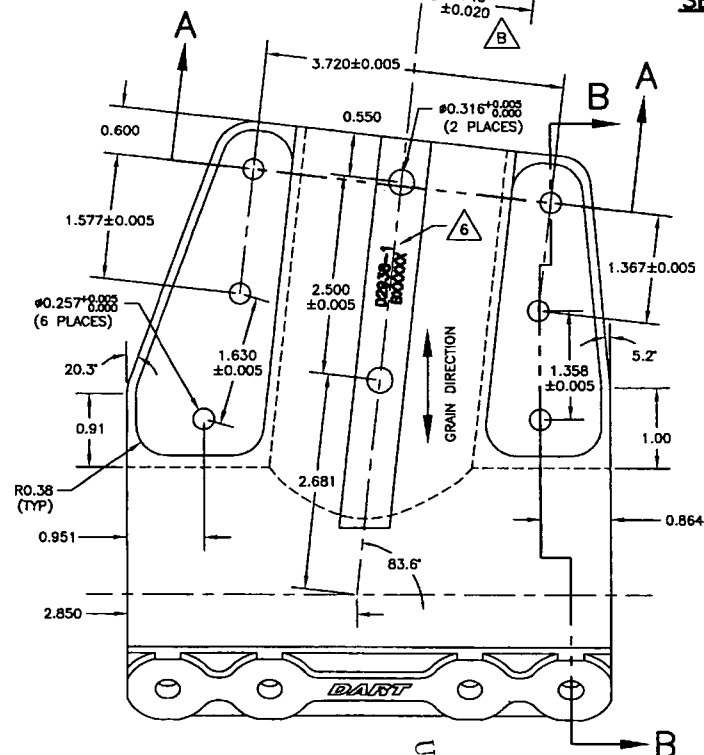
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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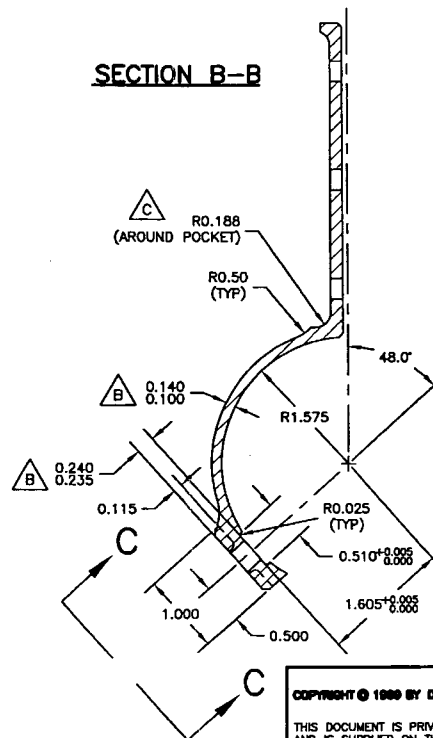
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
BELLEVUE, WA

DRAWING NO. D2938  
REV. C  
SHEET 1 OF 1

SCALE  
2:3

RELEASED

07.02.12

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